

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008675**Date Inspected:** 23-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as OBG 3BW and 2AE. The weld designations reviewed are as follows:

3BW

1. LD011-001-003

2AE

1. OB2AE-012~020, 028, 031, 038

1AE & 1AE

SMAW welding of weld joint 001 located on OBE1A.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair.

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SMAW welding (VT repair) of weld joints 931~945 located on SEG2E.

Welder is identified as Mr. Yun Chengxian (045738). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair.

SMAW welding (VT repair) of weld joints 972~985 located on SEG2E.

Welder is identified as Mr. Yun Chengxian (045738). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair.

FCAW welding of weld joint 001 located on OBE1.

Welder is identified as Mr. Ji Hongwei (058245). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-FCM-Repair and repair procedure WR7127.

FCAW welding of weld joint 009 located on OBE1.

Welder is identified as Mr. Ji Hongwei (058245). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-FCM-Repair and repair procedure WR7125.

FCAW welding of weld joint 001 located on OBE1.

Welder is identified as Mr. Jiang Yonsheng (045240). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-FCM-Repair and repair procedure WR7127.

SMAW welding of weld joint 003 located on OBE1A.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair and repair procedure WR7127.

SMAW welding of weld joint 003 located on OBE1A.

Welder is identified as Mr. Ji Yi (045268). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair and repair procedure WR7127.

NDT Observation

QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trail assembly yard. Locations are as followed:

1. Bottom Plate stiffeners bevel ends on 1BE (Panel Point 12).
2. Bottom Plate stiffeners bevel ends on 2AE (Panel Point 13).

QA Inspector observed ZPMC Ultra Sonic Testing (UT) Technician performing UT on various locations in the trail assembly yard. Locations are as followed:

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1. 1AAE to 1AE Edge Plate weld joint on the bike path side.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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| Inspected By: | Alaniz,Joe | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
